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~~Sub 82 > METHOD FOR PRODUCING A BALL-AND-SOCKET JOINT BETWEEN
A SLIPPER AND A PISTON, AND A BALL-AND-SOCKET JOINT
OF THIS TYPE~~

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ABSTRACT

The invention relates to a method for producing a ball-and-socket joint (1) between a slipper (3) and a piston (2) of a piston engine, comprising the following steps:
10 configuring the slipper (3) with a joint ball (4) at the end opposite the bottom surface (21); configuring the piston (2) with an overmeasure (x) on its lateral surface (2c) and a hemispherical joint recess (5) with a recess edge (7) that protrudes beyond the equator (6) of the joint recess (5), for the joint ball (4) at a front end of the piston (2);
15 bringing together the joint recess (5) and the joint ball (4); beading the recess edge (7) into a form in which it grips the joint ball (4) from behind; and finishing the lateral surface (2c) of the piston (2). The following steps are also provided for the purpose of simplifying and improving the production process: bringing together the joint recess (5) and the joint ball (4) after finishing the lateral surface (2c) of the piston (2); locally
20 heating the recess edge (7) to a temperature that reduces its hardness; and beading the recess edge (7).

NOTE TO EXAMINER